

Date: Wednesday, 4/26/2006 7:13:27 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)	
Job Number	: 26844A		Part Number	: D2221	
Estimate Number	: 10189		Drawing Number	: D2221/D2235	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/26/2006 S.O. No. : N/A		Drawing Revision	: F/B1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/3/2006	
Previous Run	: 26721C		Qty:	1 Um: Each	
Written By	: See COMMENT Below				
Checked & Approved By	: See ABOVE USER & DATE				
Comment	: Est Rev.J 05.09.02 Added D3442-1KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	4 D3166-1	RIB	<i>B26717</i> CPL 06-05-01
2.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	2 D2232-3	Hinge bracket	<i>B25239</i> CPC 06-04-27
3.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	<i>B26922 → 3</i>
	Qty Part Number	Description	Batch
	4 D2325	Support Gusset	<i>B25687 + 1</i> CPC 06-04-27
4.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty Part Number	Description	Batch
	2 D2327-3	Bushing	<i>B25823</i> CPC 06-04-27

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Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket BZ6204 CPC 06-04-27

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim 326739 CPC 06-05-05

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal M100722 CPC 06-05-02

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M100748 → 336,01 CPC 06-05-01

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

CPC 06-05-10

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

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Description :

10.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-05-00

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-05-10

①

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



J 06-05-10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M160901

Expiry date: 11/2006

SAD 06-05-16

①

14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① P 06/05/18

Job Completion



U 06-05-18

